

Date: Wednesday, 1/9/2008 3:42:08 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	LITTER TIE DOWN ASS'Y		
Job Number	36696		Part Number	D2350		
Estimate Number	10360		Drawing Number	D2350 / D2363		
P.O. Number			Project Number	N/A		
This Issue	1/9/2008	S.O. No.	Drawing Revision	B / E		
Prsht Rev.	NC		Material			
First Issue	/ /	Type	MACHINED PARTS	Due Date	1/31/2008	Qty: 6 Um: Each
Previous Run	33777					
Written By	10/08/01/09					
Checked & Approved By						
Comment	est rev B 06.05.17 added ass'y EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6201	T Extrusion 4X4X3/8
		Comment: Qty.: 1.0631 f(s)/Unit Total : 6.3788 f(s) Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion Batch: B35952X4 B29367X1 <i>36793 X1</i> <i>on 08/02/09</i>
2.0	BAND SAW	BAND SAW
		Comment: BAND SAW Cut blanks: 12.150" long <i>on 08/02/09</i> (6)
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio D2363 and Dwg D2363 <i>J.L 08/02/09</i> (6)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>J.L 08/02/09</i> (6)
5.0	QC8	SECOND CHECK
		Comment: SECOND CHECK <i>10 08/02/09</i> (6)
6.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 Tumble & deburr <i>J.L 08/02/09</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/9/2008 3:42:08 PM
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Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 36696

Part Number: D2350

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1/9/08-02-11 (6)

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-02-12 (6)

9.0 POWDER COATING

POWDER COATING



M107005

(6x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-f 08/02/12

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



SPH

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-02-12

(X6)

11.0 D2372

Quick Release



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2372

Fastener

b 37448

mf

12.0 D2444

Pip Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2444

Pip Pin

b 37070

mf

13.0 AN960JD10L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

3 AN960JD10L

Washer

m104885

mf 08-03-05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 1D Date: 08/03/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/9/2008 3:42:08 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 36696

Part Number: D2350

Job Number:



Seq. #: Machine Or Operation:

Description :

14.0 MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 MS21042L3 Nut (or -3) m106242

MP

15.0 MS27039113

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-1-13 Screw m13719

MF 08-03-05

16.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2350

MF

08-03-03(6)

17.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6 08/03/05 FG

18.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 185

8/3/5

SCP

6X

19.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

6 08/03/06

Job Completion



~ 2008/3/05

6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36696
Description: Litter Tie Down Bracket	Part Number:	D2363
Inspection Dwg: D2363	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.L	Audited by:	RD	Prototype Approval:	N/A
Date:	08/02/09	Date:	08/02/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.22	New Issue P/O D2350	KJ/JLM	
B	07.07.17	Dimensions updated per Dwg Rev. F	KJ/JLM	E

DART

DESIGN B. WILLIAMS	DRAWN BY B. WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>JF</i>	DRAWING NO. D2350	REV. B SHEET 1 OF 2
DATE 95:02:20		TITLE LITTER TIE DOWN ASSEMBLY	SCALE

RELEASED
960607

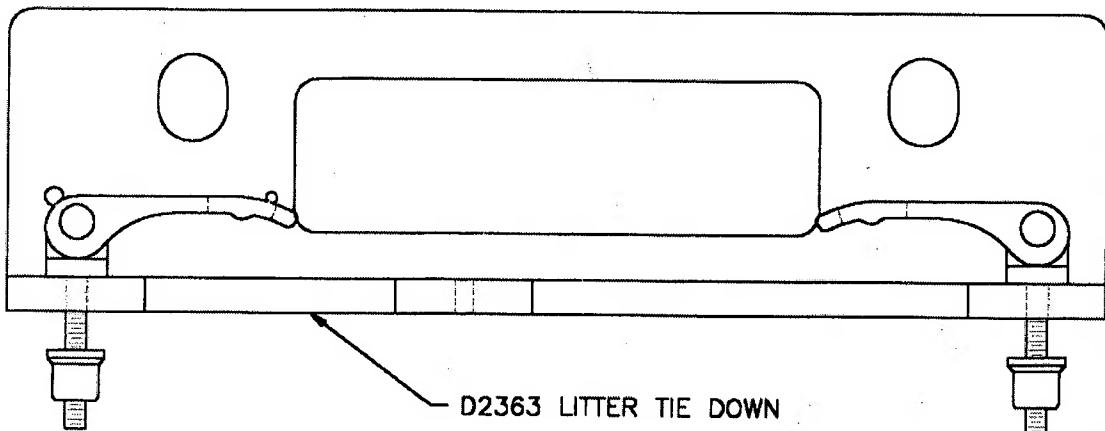
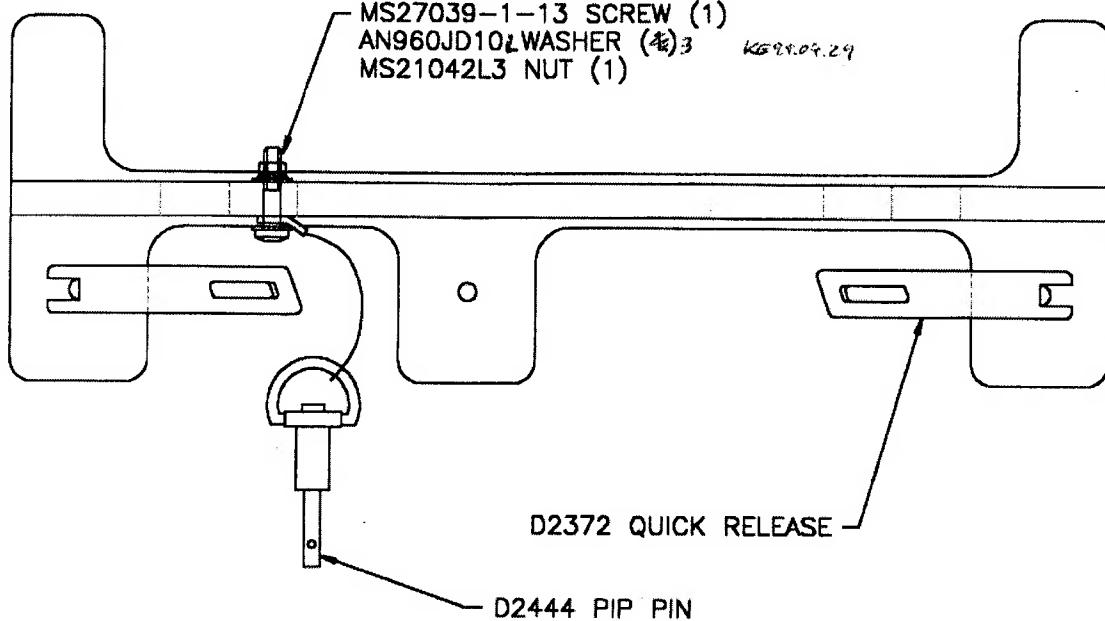
D2350	Part No.	Description
X	D2350	LITTER TIE DOWN ASSEMBLY (NON-LOCKING)
1	D2363	LITTER TIE DOWN (NON-LOCKING)
2	D2372	QUICK RELEASE FASTENER
1	D2444	PIP PIN
<i>X 3</i>	AD960JD10 L	WASHER
1	MS21042LB	NUT
1	MS27039-A-13	SCREW

KE 98.04.29

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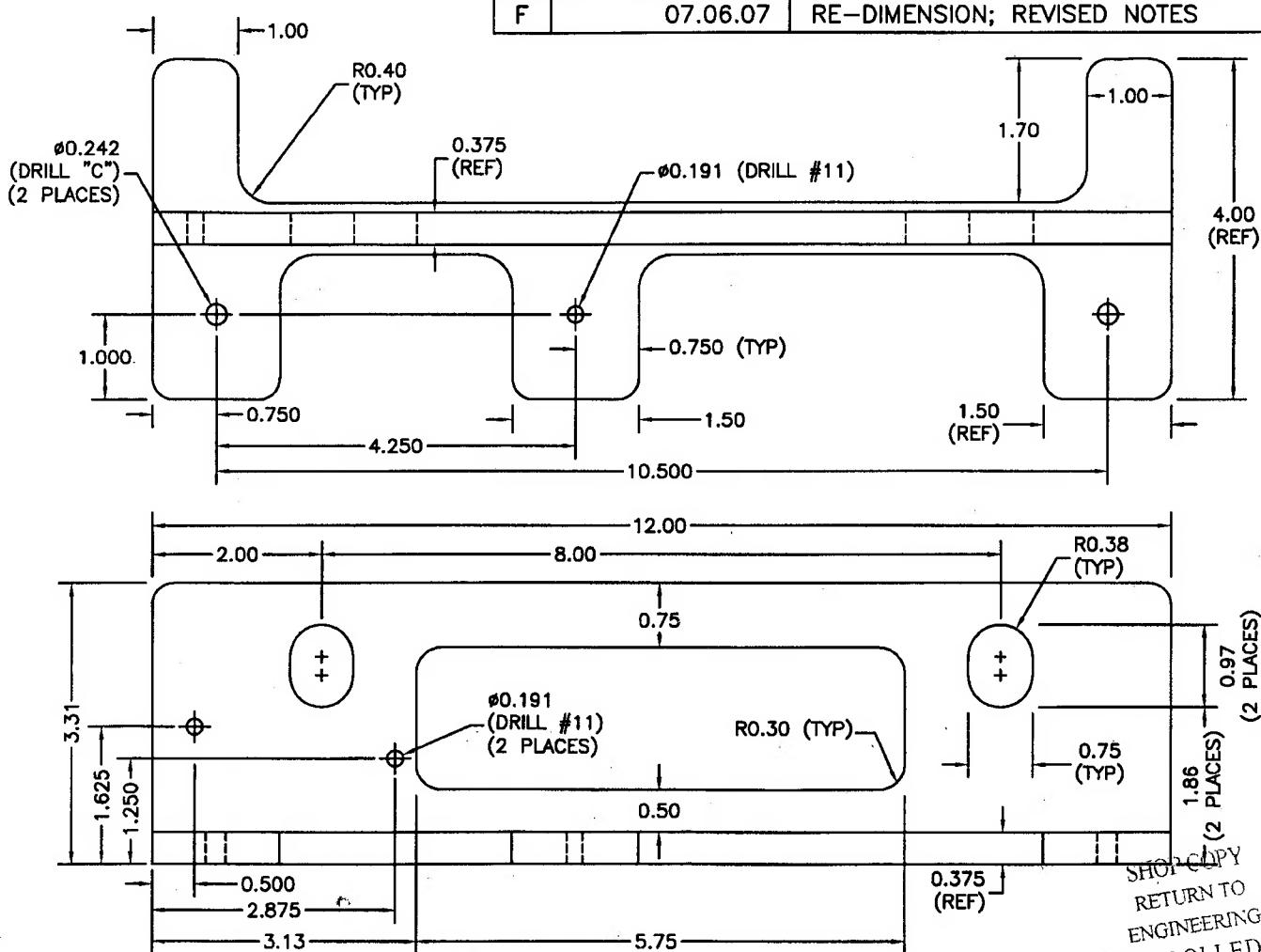
DESIGN B. WILLIAMS	DRAWN BY B. WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED P.W.	APPROVED <i>[Signature]</i>	DRAWING NO. D2350	REV. B SHEET 2 OF 2
DATE 95:02:20		TITLE LITTER TIE DOWN ASSEMBLY	SCALE

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96 06 07

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WORK ORDER
NO. 36696

DART

DESIGN BW	DRAWN BY <i>JL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AS</i>	APPROVED <i>AS</i>	DRAWING NO. D2363	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER TIE DOWN BRACKET	SCALE 1:2
A	95.01.14	NEW ISSUE	
B	95.02.14	MODIFIED HOLES	
C	95.03.06	0.191 WAS 0.197	
D	95.03.06	CHANGES TO DIMENSIONS	
E	97.10.01	CHANGES FOR MACHINING	
F	07.06.07	RE-DIMENSION; REVISED NOTES	



D2363 LITTER TIE DOWN BRACKET

- 1) MATERIAL: MAKE FROM D6201-012 EXTRUSION (6061-T6/T651 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N "D2363" USING FINE POINT PERMANENT INK MARKER

RELEASED

07.06.07 *AS*



WORK ORDER
NO. 36696
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